

Date: Monday, 7/9/2007 11:47:23 AM
 User: Kim Johnston

Process Sheet

split w/o
80 08/03/13

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STUD
Job Number : 33369 -1	
Estimate Number : 10543	
P.O. Number :	Part Number : D30281
This Issue : 7/9/2007 S.O. No. :	Drawing Number : D3028 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 24630	Material :
Written By :	Due Date : 7/30/2007 Qty: <i>25</i> Um: Each
Checked & Approved By : <i>Don. 07.09</i>	
Comment : Est.B 02.09.10 Made on Cobra KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NR0750	4130 steel rod .750"
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Comment: Qty.: 0.1313 f(s)/Unit Total : 3.9375 f(s)

4130 steel rod .750"

Material: AISI 4130N Bar per MIL-S-6758 or AMS 6348/ 6370/ 6528 Ø0.750"(M4130N-R0.750)

B

atch *M104452*

Threads per MIL-S-7742

H.A 08/01/11

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: ~~BAND SAW~~ *HARDINGE*

1-Turn blank per Dwg D3028 and FA263

2-Cut groove as per Dwg D3028 and FA263

3-Deburr and Tumble for a short time to prevent damage to threads

H.A/BK 08/01/11

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L/H.A/BK 08/01/11

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

10/08.02/12 (30)

5.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH
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Comment: Sub-Contracting PURCHASING

Issue P/O: *5683*

C208/02/12 (25)

Finish : Cadmium plate per QQ-P-416F Class 1, Type II

Material release note is required.

P.T.O

[Signature]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.02.11	5	took 4 unplated for HAI	LC	08.02.11	4	LC	

Part No: D3628-1 PAR #: N/A Fault Category: Prod / Machines Parts NCR: Yes No DQA: D Date: 08/03/14
 QA: N/C Closed: H Date: 08/03/14

NCR: <u>33369</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.02.11	22	one part scrap origin was wrong R.C. Hammer error	CP 08.02.11 PV DS1042	SCRAP & REPLACE no replace Qty (51)	J.L 08/02/11	J 08/02/11	CP 08.02.11 PER DS1042	J 08/02/11

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:47:23 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STUD

Job Number: 33369

Part Number: D30281

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

Identify and Stock

Location: ST60

1-8/3/3

22 08/03/13

(25)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

25 08/03/14

(25)

Job Completion



2008/3/14

(25)

→ 6.1 QC 6 8/03/13 (+25)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

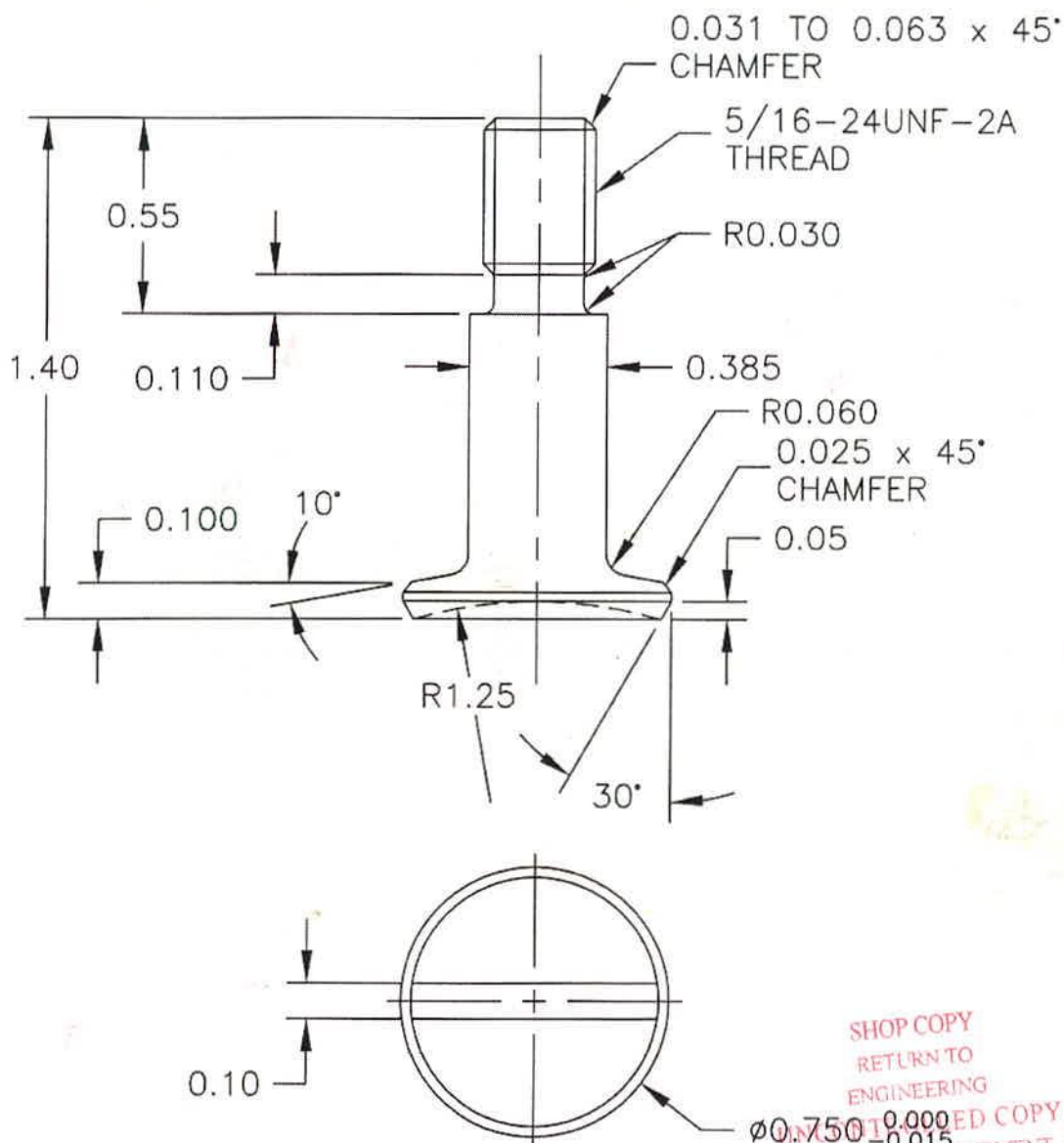
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3028	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE STUD	SCALE 2:1
A	01.05.18	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



D3028-1:

- 1) POSSIBLE SUPPLIER: NORTHERN AERO INDUSTRIES P/N B83602-1
- 2) MATERIAL: AISI 4130N BAR PER MIL-S-6758 OR AMS 6348/6370/6528
- 3) THREADS PER MIL-S-7742
- 4) FINISH: CADMIUM PLATE PER QQ-P-416F CLASS 1, TYPE II
- 5) ALL DIMENSIONS ARE IN INCHES.
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33369

RELEASED
a.05.30 #

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DART AEROSPACE LTD		Work Order: 33369
Description: STUD		Part Number: D30281
Inspection Dwg: D3028 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .750	+/- .010	Ø .745	✓			
1.40	+/- .030	1.397	✓			
0.110	+/- .010	.110	✓			
0.100	+/- .010	.100	✓			
0.05	+/- .030	.050	✓			
0.55	+/- .030	.565	✓			
Ø .385	+/- .010	Ø .385	✓			
0.031 ± 0.003 x 45°	.031 to .063	.058 x 45°	✓			
0.025 x 45°	+/- .010	0.025 x 45°	✓			
R.060	+/- .010	R.060	✓			
R.030	+/- .010	R.030	✓			
5/16-24UNF-2A	Min= .328 Max= .3243	.326	✓			
30°	+/- 1/2°	30°	✓			
10°	+/- 1/2°	10°	✓			
0.10	+/- .030	.097	✓			CNC milling
R1.25	+/- .030	R1.25	✓			CNC milling

Measured by: D.A. / S.E.L.	Audited by: [Signature]	Prototype Approval:
Date: 08/01/11	Date: 08/02/09	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	



Placage

Manco Domplex

Electroplating

Siège social / Head Office Plan 1

4660 Hickmore

Ville St-Laurent, Québec

H4T 1K2

Fax: 514-355-8750

Plan 1

4670 Hickmore

Ville St-Laurent, Québec

Fax: 514-355-5991

Plan 2

8001 Larrey

Anjou, Québec

Fax: 514-354-2937

BON DE LIVRAISON**PACKING SLIP**

Tél.: 514-355-7867 / 1-877-355-7867

V S
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DART Aerospace LTDE
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A
DART Aerospace LTD
1270 Abbeville St
HAWKSBURY ONT K6A1

DATE DE COMMANDE ORDER DATE		DATE D'EXPÉDITION DATE SHIPPED		NO. DE COMMANDE P.O. NO.	
VIA		PRÉPARÉ PAR PREPARED BY		POUR INFO. CONTACTER	
N° DE COMM. P.O. NO.	DESCRIPTION			QUANTITÉ QUANTITY	UN
	D2968-0411 B33099 Yellow Cadmium 5				
	D3028-1 B33369 Yellow Cadmium 25				
POIDS TOTAL TOTAL WEIGHT		REÇU PAR RECEIVED BY		# BON DE LIVRAISON	
SIGNATURE		TOTAL DE COLIS TOTAL PARCELS		109405	

AUCUNE RÉCLAMATION APRÈS 5 JOURS DE LA DATE DE LIVRAISON
NO CLAIMS AFTER 5 DAYS FROM DATE OF DELIVERY

COPIE BLANCHE / WHITE COPY: BUREAU / OFFICE - COPIE VERTE / GREEN COPY: CONFIRMATION D'EXPÉDITION / SHIPPING CONFIRMATION
COPIE ORANGE / ORANGE COPY: CLIENT / CUSTOMER - COPIE BLEU / BLUE COPY: FICHE D'EXPÉDITION / SHIPPING FILE

MANCO
DOMPLEX

8895 Crescent 3
Anjou (Québec) H1J 1J6
Tél.: (514) 355-7867
Fax: (514) 355-8750

ATTN: CHANTAL - 1613-632 1053

CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE

#424

Dart Aerospace Ltd
Client / Customer

105683

Votre # de commande / Your purchase order #

1 Lot of fives
de la pièce / part

109405

Notre # de bon de livraison / Our packing slip #

Inspecteur / Inspector <u>Levalet</u>	Date, équipe / Date, shift <u>Feb 28, 2008</u>
Placage / Plating <u>QCP 416 E CII Type II</u>	
Quantité totale / Total quantity <u>1 Lot</u>	Quantité inspectée / Inspected quantity <u>1 Lot</u>
Adhésion / Adhesion <u>Good</u>	
Épaisseur / Thickness L.C.D.	H.C.D. Moy. / aver. <u>0.0005</u>
Coussures, taches / Leach, spots <u>None</u>	Rugosité / Roughness <u>None</u>
Quantité approuvée / Approved quantity <u>1 Lot</u>	Quantité rejetée / Rejected quantity <u>—</u>

Commentaires / Comments

D2768-041 B33099 = 5 Pcs

D3028-1 B33369 = 25 Pcs

Nous certifions que les pièces énumérées ci-dessus ont été faites en conformité avec vos dessins et spécifications et rencontrent les exigences contenues dans ces dessins et/ou spécifications.

We hereby certify that the parts listed above have been made in accordance with your drawings and specifications and are correct to the requirements contained in those drawings and/or specifications.

Signé au nom de
Signed on behalf of

MANCO
DOMPLEX